

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023899**Date Inspected:** 14-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

FCAW welding of weld joint DP3160-001-127 located on PCMK OBG 14E. Welder was identified as 067877.

QC was identified as ZPMC CWI Li Yan Hua (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Xie Ming Feng (QCA1), who was not a CWI.

Weld variables recorded by QCA1 appeared to comply with WPS-345-FCAW-3G(3F)-ESAB-repair as verbally identified by QCA1.

SMAW welding of weld joints SEG3019AE-022, 023, 029, 030, 036, 037, 043, 044, 050, 051, 057, 058 located on PCMK OBG 14E. Welder was identified as 216086. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2214-FCM-1 as verbally identified by QCA1.

SMAW welding of weld joints SEG3019AG-010, 011, 014, 015, 058, 087 located on PCMK OBG 14E. Welder was identified as 216086. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2112-FCM-1 as verbally identified by QCA1.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW welding of weld joints SEG3019AF-008, 009, 015, 016, 022, 023, 029, 030, 036, 043, 044 located on PCMK OBG 14E. Welders were identified as 215553, 044779. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2214-FCM-1 as verbally identified by QCA1.

SMAW welding of weld joint SEG3019*-018 located on PCMK OBG 14E. Welder was identified as 066733. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2212-FCM-1 as verbally identified by QCA1.

FCAW welding of weld joints SEG3009J-085, 090, 095, 100, 105, 110, 115 located on PCMK OBG 14E. Welder was identified as 052696. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA1.

SMAW welding of weld joint FB3115-001-040 located on PCMK OBG 13AE. Welder was identified as 043661. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2114-FCM-1 as verbally identified by QCA1.

FCAW welding of weld joints SEG3007B-093, 097, 101, 105, 117 located on PCMK OBG 13BE. Welder was identified as 050977. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA1.

SMAW repair welding of weld joints VP3007-001-044; VP3008-001-009 located on PCMK OBG 13BE. Welder was identified as 058102. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-345-SMAW-1G(1F)-repair-1 and WPS-345-SMAW-4G(4F)-repair-1 as displayed on ZPMC Weld Repair Reports B-WR20767 and B-WR20769, respectively, as presented to this QA Inspector and verbally identified by QCA1.

SMAW welding of temporary alignment plates located across the PCMK OBG 13CW/14W transverse joint, deck plates. Welder was identified as 055564. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2134-ESAB as verbally identified by QCA1. See photo below of welding operation in progress.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
